

Work Order ID 131566

Wednesday, April 15, 2015 1:38:01 PM

131566

Page 1

Item ID: D3536-35

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Gasket Aft

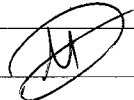
Start Date: 4/15/15 Start Qty: 50.00 ***50***

Cust Item ID:

Required Date: 4/17/15 Req'd Qty: 50.00 ***50***

Customer:

Reference:

Approvals: Process Plan:  Date: 15-4-15 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3536	Rev A								

100

0.00

100

Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3536 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

65 $\emptyset$ Jm15-4-18

neo60(063)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

65 $\emptyset$ Jm15-4-18

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

65 $\emptyset$
 DWS 38 9-89
 APP 2 0 2015

Work Order ID 131566***131566***

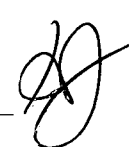
Page 2

Wednesday, April 15, 2015 1:38:01 PM

Item ID: D3536-35 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Gasket Aft
Start Date: 4/15/15 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 4/17/15 Req'd Qty: 50.00 ***50*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: FG 001	0.00							
130									
Packaging	Memo	0.00				6S	27		
Packaging							APR 21 2015		
140	QC21 - Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

15/4/22 

 S-4-21

Picklist Print

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Page 1

Work Order ID: 131566

131566

Parent Item: D3536-35

D3536-35

Parent Item Name: Gasket Aft

Start Date: 4/15/15

Required Date: 4/17/15

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased		No		100	sf	400.0000	0.6197	35			
MNEO60S 063									**		Jm15-0		
NEOPRENE SHEET 0.063													

Location

Loc Qty

Loc Code

MAT052

400

M131990

400

131990

DART AEROSPACE LTD		Work Order:	131566
Description: Gasket		Part Number:	D3536-35
Inspection Dwg: D3536 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
23.25	+/-0.030	23.25	-		T	Jkm07
19.75	+/-0.030	19.75	-		T	
17.75	+/-0.030	17.75	-		T	
14.25	+/-0.030	14.25	-		T	
9.50	+/-0.030	9.50	-		T	
4.75	+/-0.030	4.75	-		✓	Jkm01
2.00	+/-0.030	2.00	-		✓	
6.00	+/-0.030	6.00	-		✓	
6.75	+/-0.030	6.75	-		✓	
0.30	+/-0.030	0.30	-		✓	
0.30	+/-0.030	0.30	-		✓	
1.89	+/-0.030	1.89	-		✓	
Ø0.19	+0.005/-0.001	0.19	-		✓	
0.063	+/-0.010	0.063	-		✓	

Measured by:	Jm
Date:	15-4-18

Audited by:	38
Date:	APR 20 2015

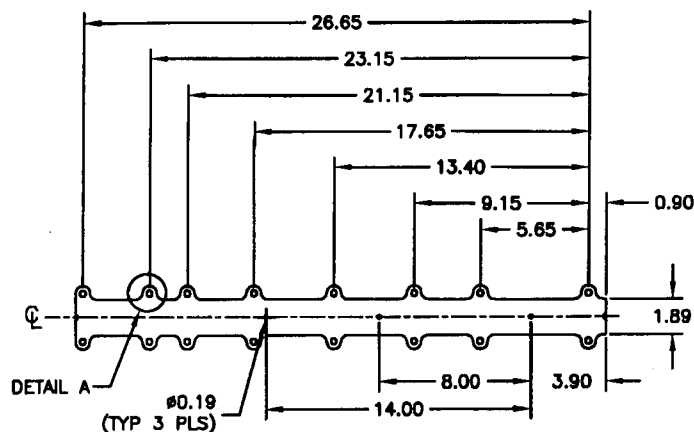
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	

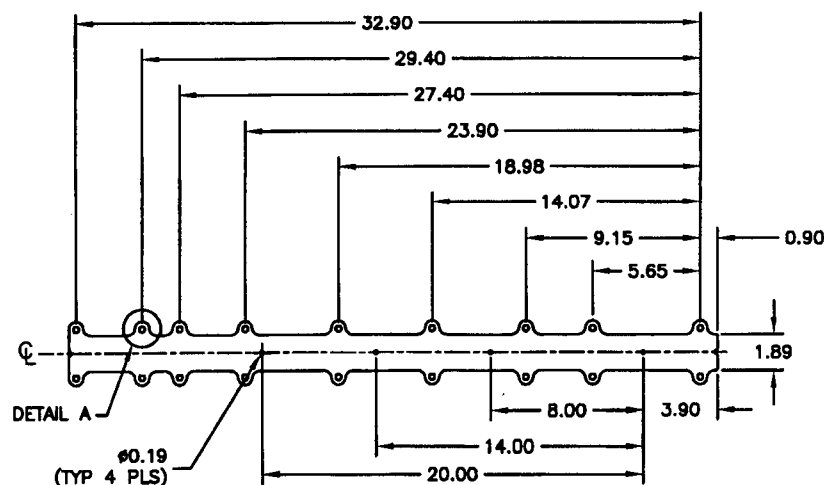


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09-02-12-11

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CB	CB	PORT HADLOCK, WA	
CHECKED PH	APPROVED H	DRAWING NO. D3536	REV. A
DATE 06.10.25	TITLE GASKET	SHEET 1 OF 6	SCALE 1:10
A	06.10.25	NEW ISSUE	



D3536-11 GASKET



D3536-13 GASKET

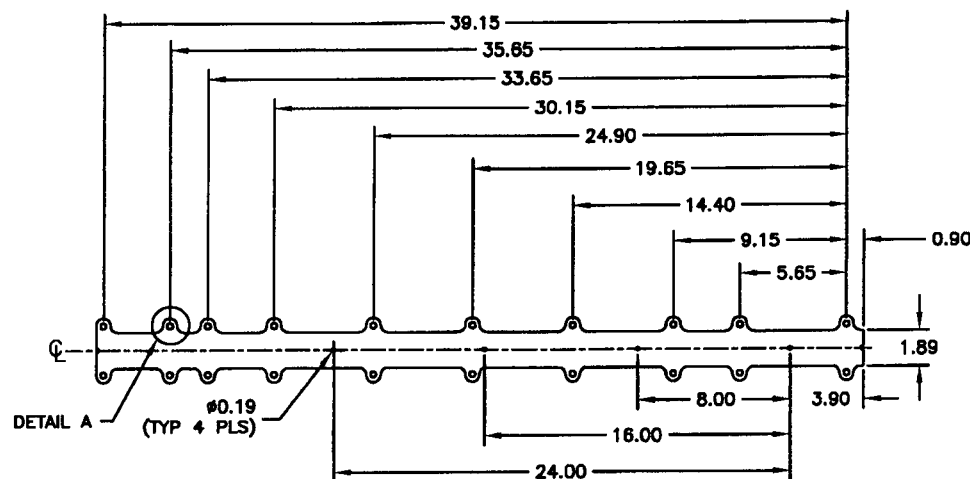
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

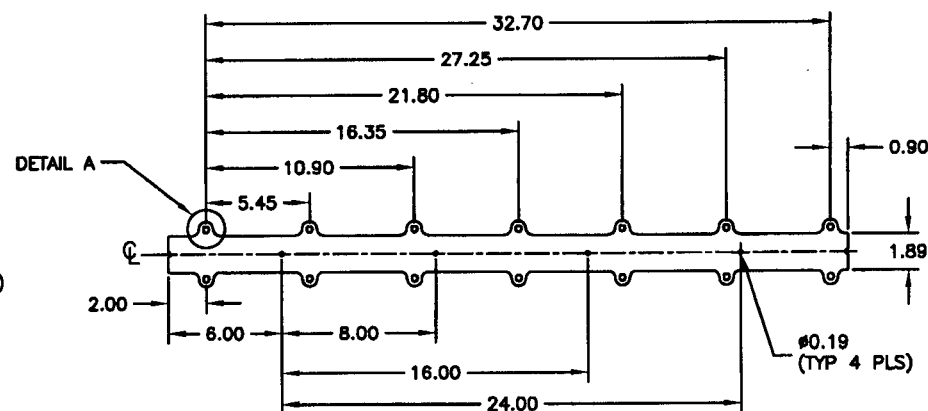
131566
15-4-15



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070212



D3536-15 GASKET

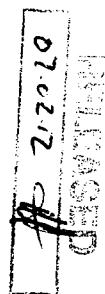


D3536-21 GASKET

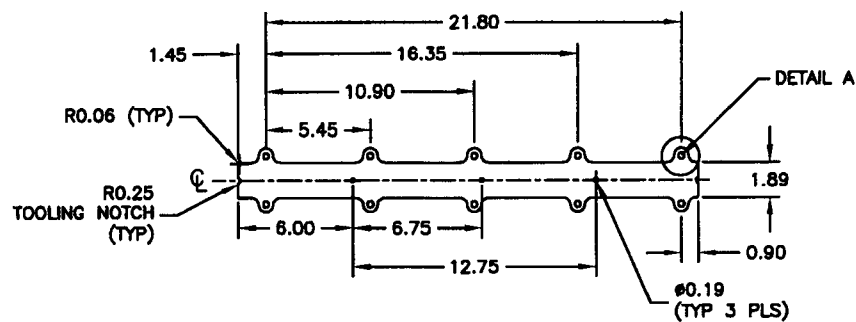
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
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DATE	06.10.25	TITLE	D3536	REV. A
		GASKET		SHEET 2 OF 6
				SCALE 1:10



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DATE 06.10.25	TITLE GASKET		SCALE 1:10



D3536-25 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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- 7) SEE PAGE 6 FOR DETAILS AND SECTION

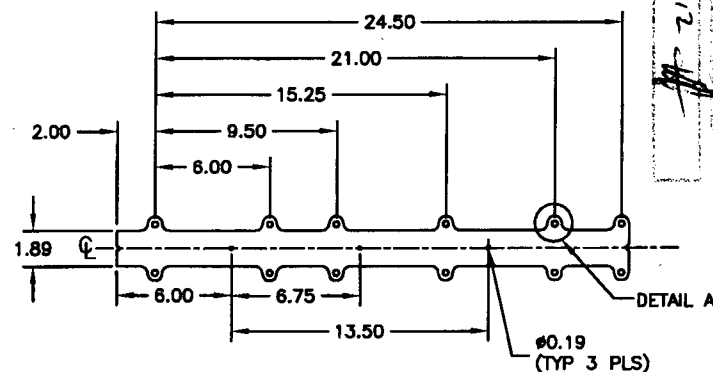
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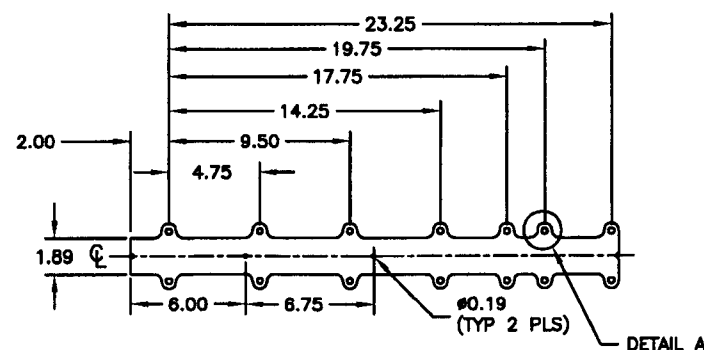


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DATE	06.10.25	TITLE	D3536	REV. A
			GASKET	SHEET 4 OF 6
				SCALE 1:10

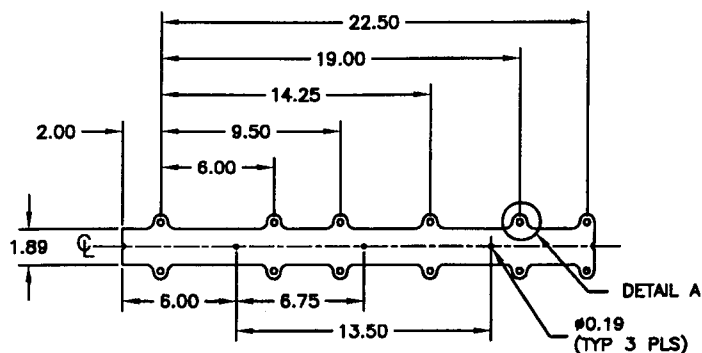
REWORKED
07.02.12



D3536-33 GASKET



D3536-35 GASKET



D3536-31 GASKET

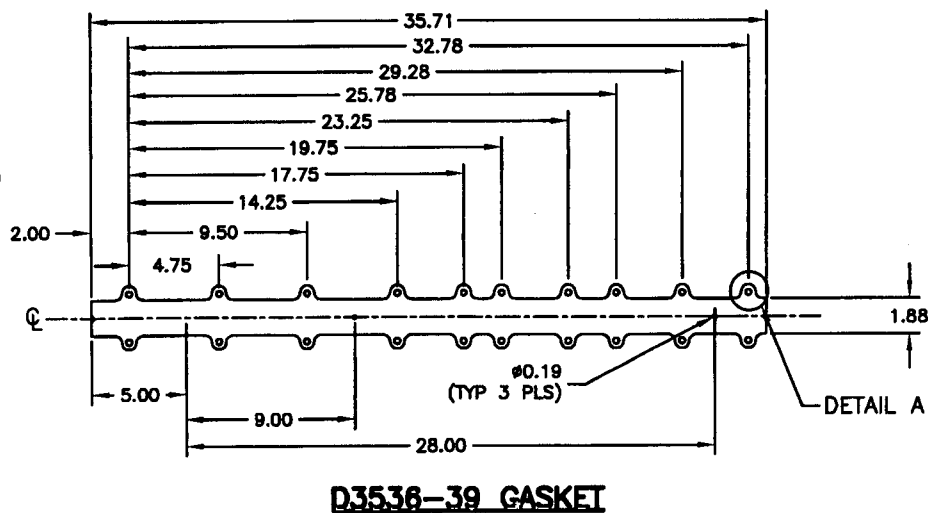
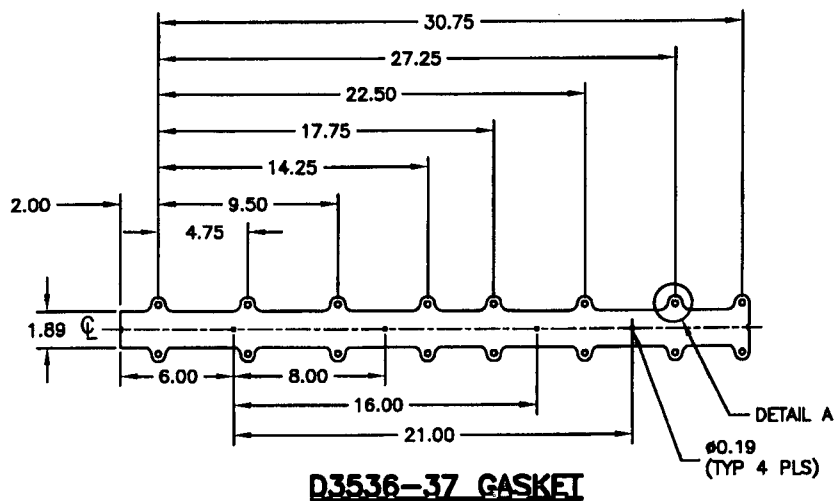
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 5 OF 6
		SCALE	1:10	

07.02.02 CH



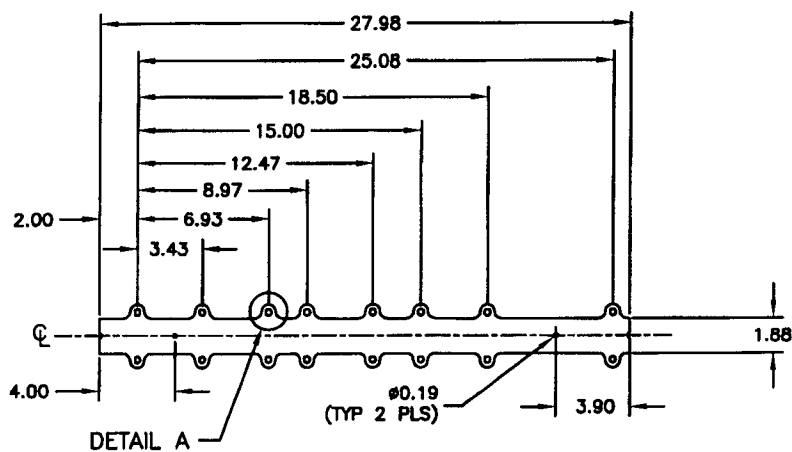
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT ϕ
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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DATE	06.10.25	DRAWING NO.	D3536	REV. A
		TITLE	GASKET	SHEET 6 OF 6
		SCALE	1:10	



D3536-41 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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